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(54) Title: **TABLETTED CHEWING GUM SWEET**

(57) Abstract: A tabletted chewing gum sweet characterised in that it comprises at least two integral parts, a first integral part com-  
prising a compressed gum base and a tablet base material, and a second integral part comprising a compressed tablet base material.  
In the mouth, the tablet exhibits a first crunchy stage which changes to a second chewing gum stage.

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## TABLETTED CHEWING GUM SWEET

### FIELD OF THE INVENTION

The present invention relates to a tabletted chewing gum sweet and more especially a tabletted chewing gum sweet comprising at least two integral parts which has a novel effect in the mouth by giving an initial crunch followed by a normal chewing gum stage.

### BACKGROUND OF THE INVENTION

Ordinary chewing gum contains a generally neutral and essentially tasteless insoluble masticatory gum base which is usually a plasticised rubber or polymer which is softened and has added texturisers, anti-tacking agents and antioxidants, etc. The base is to be chewed rather than eaten in itself and is a vehicle for one or more non-masticatory active ingredients such as flavours and sweeteners.

EP-A-0 253-040 discloses a chewing gum hard candy confection which softens in the mouth to a chewable mass upon mastication prepared by mixing a melted gum base with a cooked hard candy syrup and cooling to a hard candy matrix. Hard candy is usually made from a base of a bulk sweetener such as sugar and glucose syrup which normally contain about 95-98% of the product. The hard candy syrup comprising sugar, glucose syrup and water is cooked to a temperature of 127° to 185°C before adding the melted chewing gum base.

Tablets are characterised by being hard and somewhat brittle with a smooth surface and differ from hard candy in that they are formed by compressing a tablet base powder in a die where the particles bond together under pressure and the compacted tablet is ejected from the die. The tablet base material is a sugar or a polyol, e.g. sucrose, fructose, dextrose, sorbitol, mannitol, maltitol or xylitol. Tablets may be chewed in a crumbly state and eventually swallowed.

## SUMMARY OF THE INVENTION

The present invention comprises a tabletted chewing gum sweet comprising at least two integral parts which has a novel effect in the mouth by giving an initial crunch followed by a normal chewing gum stage.

Accordingly, the present invention comprises a tabletted chewing gum sweet characterised in that it comprises at least two integral parts, a first integral part comprising a compressed gum base and a tablet base material, and a second integral part comprising a compressed tablet base material.

## DETAILED DESCRIPTION OF THE INVENTION

The tabletted chewing gum sweet may comprise one or more further integral parts which may be made of the same material as the first and second integral parts or of a different material to the first and second integral parts. The integral parts may be arranged in a variety of configurations, e.g. as two or more layers which may be on top of one another or side by side, one integral part may be inlaid in another integral part, or one integral part may be completely enclosed within one or more other integral parts. The embodiment where one integral part is completely enclosed within one or more other integral parts is advantageous where the enclosed integral part is moisture sensitive.

In a tabletted chewing gum sweet of the invention where the integral parts are arranged as layers, the individual layers may be of the same or different thicknesses. In a tabletted chewing gum sweet consisting of two layers, either layer may be thicker than the other, e.g. the ratio of thicknesses may be from 0.1:1 to 10:1, but preferably the first integral part of the tabletted chewing gum sweet according to the invention is thicker than the second integral part, e.g. the ratio of thicknesses may be from 1.5:1 to 10:1 and preferably from 2:1 to 5:1.

The gum base may be any gum base well known to those skilled in the art and may be a plasticised rubber or polymer which may have added texturisers, anti-tacking agents and antioxidants. A particularly advantageous gum base is ARTICA-T made by Cafosa Gum S/A of Barcelona, Spain. Artica-T is composed

of the following classes of materials: specially purified elastomeric polymers, resins, refined waxes, glycerol esters of edible fatty acids, talc, antioxidant.

The tablet base material used for both the first and second integral parts of the tabletted chewing gum sweet may contain sugar or be sugar-free and is preferably based on a sugar or a polyol, for example, sucrose, fructose, lactose, dextrose, sorbitol, mannitol, maltitol, xylitol, isomalt, glucose syrup, maltitol syrup or erithritol. The tablet base material for both the first and second integral parts may be in particulate form, preferably powder form. (e.g. direct compressible grade sorbitol).

Either or both of the integral parts of the tabletted chewing gum sweet may contain a binder, a lubricant, a flavour or a colour. The binder for a sugar may be, for instance, a mixture of glucose syrup and starch gum, e.g. in an amount of from 1-3% by weight based on the weight of the second integral part. Generally, a binder is unnecessary for sorbitol since sorbitol is directly compressible. However, if desired, lycasin may be added to the sorbitol in the first integral part of a sugar-free product and glucose may be added to the first integral part of a sugar-containing product e.g. in an amount from 1-10% and preferably from 2.5 to 7.5% by weight based on the weight of the first integral part. The flavour may be, for instance, mint, spearmint, peach, pear, strawberry, raspberry, vanilla, etc. Preferably, the first and second integral parts have different colours which may provide interesting contrasting effects to give a very distinctive and attractive visual indication of two components.

The first integral part of the tabletted chewing gum sweet according to the invention may be prepared by compressing a mixture of the gum base and the tablet base material.

The second integral part of the tabletted chewing gum sweet according to the invention may be prepared by compressing the tablet base material.

The particle sizes of the gum base and the tablet base of both the first and second integral parts may range from 10 microns to 2mm, but the average particle size may be from 20 to 160 microns, preferably from 30 to 120 microns and more preferably from 50 to 100 microns.

Preferably, in the first integral part of the tabletted chewing gum sweet, the gum base is present in an amount of from 5% to 99%, preferably from 10% to 50% and more preferably from 20% to 30% by weight and the tablet base is present in an amount from 1% to 95%, preferably from 50% to 90% and more preferably from 70% to 80% by weight based on the weight of the first integral part of the product.

The weight ratio of the first and second integral parts when there are 2 layers may be from 1.5:1 to 10:1 and preferably from 2:1 to 5:1.

Optionally, the tabletted chewing gum sweet may contain an active ingredient. The active ingredient may be a pharmaceutical, medicated, nutritive or functional ingredient, a dental vehicle such as casein glyco-macro-peptide (CGMP) or a breath freshener. For instance, the active ingredient may be any vitamin, enzyme, amino-acid supplement, protein, gum, carbohydrate, phytochemical, dextrose, lecithin, other trace nutrient, brain-stimulating substance, energy provider, a mineral, mineral salt, botanical extract, antioxidant, prebiotic, probiotic bacteria, fatty acid, oat beta glucan or other functional fibre, creatine, carnitine, bicarbonate, citrate, vivazol, or any mixture thereof.

The amount of active ingredient present in the tabletted chewing gum sweet may depend on requirements and the actual ingredient used. For instance, some active ingredients have high functional activity at very low doses such as vitamins and minerals (micronutrients), whereas others such as dextrose (macronutrients) are beneficial to the body in much higher amounts. Furthermore, plant extracts may only contain small amounts of active constituents within the bulk of the extract and may therefore need to be added in larger amounts to ensure sufficient effective quantities of the active parts. The amount of active ingredient may, for example, be from up to 0.00000001 to 15% by weight of the chewing gum-containing tablet depending upon the ingredient. The amount of most ingredients is usually less than 1% by weight, and preferably from 0.000001 to 0.5 % by weight of the chewing gum-containing tablet. CGMP may be used in amounts up to 15%, preferably from 1 to 12% and more preferably from 2.5 to 10% by weight of the tabletted chewing gum sweet.

The mineral may be calcium, iron, selenium, zinc, magnesium, phosphorus, iodine, manganese, iron, boron or copper, molybdenum, potassium, chromium, vanadium or fluoride.

The phytochemical may be a polyphenol, procyanidin or a phenolic acid, catechin or epicatechin, isoflavone, terpene or other phytonutritive plant material.

The botanical extract may be selected from Guarana, Ginkgo Biloba, Kola nut, Goldenseal, Golo Kola, Schizandra, Elderberry, St. John's Wort, Valerian and Ephedra, beta-sitosterol, caffeine, cafestol, D-limonene, kabweol, nomilin, oltipraz, sulphoraphane, tangeretin, black tea, white tea, java tea, folic acid, garlic oil, fiber, green tea extract, lemon oil, mace, licorice, menthol, onion oil, orange oil, rosemary extract, milk thistle extract, Echinacea, Siberian ginseng or Panax ginseng, lemon balm, Kava Kava, matte, bilberry, soy, grapefruit, seaweed, hawthorn, lime blossom, sage, clove, basil, curcumin, taurine, wild oat herb, dandelion, gentian, aloe vera, hops, cinnamon, peppermint, grape, chamomile, fennel, marshmallow, ginger, slippery elm, cardamon, coriander, anise, thyme, rehmannia, eucalyptus, menthol, kava kava, schisandra, withania, cowslip, lycium, passion flower.

The antioxidant substance may be glutathione peroxidase, superoxide dismutase, catalase, co-enzyme Q10 or honey.

The prebiotic may contain fructose, galactose, mannose, soy or inulin.

The probiotic bacteria may be lactobacilli or bifidobacteria, lactococcus, streptococcus, leuconostococcus, pediococcus or enterococcus.

Preferably, the active ingredient is present in the second integral part of the tabletted chewing gum sweet.

When the tabletted chewing gum sweet contains an active ingredient, it may impart to the consumer benefits such as oral care, breath freshness, pharmaceutical or nutritive advantages.

The present invention also provides a process for the preparation of a tabletted chewing gum sweet according to the invention in a configuration of two layers which comprises forming a first integral part by mixing a particulated gum base material with a particulated tablet base material, forming a second integral part comprising a particulated tablet base material, feeding one of the integral parts into a tablet press and compressing, feeding the other integral part into the tablet press and compressing both integral parts in the tablet press to enable the materials of each integral part to bind together and form a tabletted chewing gum sweet having the two integral parts joined together, and finally ejecting the tabletted chewing gum sweet.

Conveniently, the first integral part is fed into the tablet press before the second integral part to give the tabletted chewing gum sweet.

If desired, one or more further integral parts which may be made of the same material as the first and second integral parts or of a different material to the first and second integral parts are fed into the tablet press and compressed to form a product with three or more layers.

The tablet press comprises a die and a punch and the basic principle of compression applies wherein the die is filled with powder and compressed by the punch being lowered under pressure and maintained on the powder for a period of time known as the dwell time to form the tablet after which the tablet is ejected. Many shapes and sizes of tablet may be made by varying the shape of the die and punch, e.g. circular, briquette, pillow, etc.

The present invention also provides a process for the preparation of a tabletted chewing gum sweet according to the invention in a configuration of one integral part inlaid in another integral part which comprises feeding one of the integral parts into a tablet press and compressing into a shape having an indentation, feeding the other integral part into the indentation and compressing both integral parts in the tablet press to enable the materials of each integral part to bind together and form a tabletted chewing gum sweet having the two integral parts joined together, and finally ejecting the tabletted chewing gum sweet.

The indentation may be of any desired shape or size, e.g. it may be circular, oval, angular or square in cross-section. If desired, a further integral part may be fed

into the tablet press and compressed to cover and enclose the compressed integral part in the indentation.

In the mouth, the tabletted chewing gum sweet may also give a textural contrast of an initial crunchy and then a chewy sensation. The initial crunchy sensation is obtained from the second layer which compacts to a hard crunchy layer on compression. The duration of the initial crunchy sensation may last from about 10 seconds to about 1 minute, and typically from about 25 to 50 seconds before it disappears completely. The duration of the initial crunchy sensation depends on the thickness of the second layer, thicker layers giving a longer crunchy sensation.

## EXAMPLES

The following Examples further describe the invention by way of illustration only. The gum base used in all the Examples is ARTICA-T made by Cafosa Gum S/A of Barcelona, Spain.

### Example 1

The following formulation is used to make a large circular two-layered tabletted chewing gum sweet with a hole in the middle. The following ingredients are mixed to make the integral part of the first layer :

Gum Base	21.3%
Sorbitol	71.6%
Magnesium stearate	0.5%
Spearmint Flavour (powder + liquid)	1.1%
Blue colour	0.5%

The gum base and the sorbitol are used in powder form having an average particle size of 40 microns. The flavour is a combination of powder and liquid.

The above first layer integral part is filled into the die of a tablet press comprising a suitably shaped die and punch and compressed by the punch being lowered under pressure which is maintained on the powder for a period of time known as



the dwell time to bond the particles together and compact them to form the compressed first layer.

The integral part of the second layer of tablet base material having a weight of one quarter of the weight of the first layer is made of 93.5% by weight of sorbitol having an average particle size of 40 microns, 5% by weight of CGMP, 1.0% by weight of magnesium stearate and 0.5% by weight of spearmint flavour.

The second layer of tablet base material is filled into the die of a tablet press on top of the compressed first layer and then compressed by the punch being lowered again to bond the particles and compact them to form the compressed second layer joined together to the compressed first layer to form the tabletted chewing gum sweet after which the tabletted chewing gum sweet is ejected. The tabletted chewing gum sweet has contrasting colours of blue and white with a nice even line on the join between the two layers.

In the mouth, the tablet initially has a crunchy texture which lasts for about 40 seconds and then becomes a normal cohesive chewing gum.

## Example 2

245.95 parts of a Cafosa Gum/Sorbitol premix containing the ingredients in the same proportion as in Example 1 having an average particle size of 40 microns are mixed with the following ingredients to give the integral part of the first layer:

Magnesium stearate (lubricant)	1.25 parts
Mint Oil	1.30 parts
Mint powder	1.00 parts
Menthol Trusil	0.5 parts
Green colour	0.1 part

The integral part of the second layer having a weight of one quarter of the weight of the first layer is made of powdered sugar having an average particle size of 40 microns containing 0.5% of magnesium stearate, 2.4% of a 50:50 mixture of 4% glucose syrup and starch gum, and having a red colour.

The above mixtures were compressed as in Example 1 to give a mint-flavoured tabletted chewing gum sweet having two layers with contrasting colours of blue and red.

In the mouth, the tablet initially has a crunchy texture which lasts for 40 seconds and then becomes a normal cohesive chewing gum.

## CLAIMS

1. A tabletted chewing gum sweet characterised in that it comprises at least two integral parts, a first integral part comprising a compressed gum base and a tablet base material, and a second integral part comprising a compressed tablet base material.
2. A tabletted chewing gum sweet according to claim 1 comprising one or more further integral parts which may be made of the same material as the first and second integral parts or of a different material to the first and second integral parts.
3. A tabletted chewing gum sweet according to claim 1 wherein the integral parts are arranged as two or more layers on top of one another or side by side, or one integral part is inlaid in another integral part, or one integral part is completely enclosed within one or more other integral parts.
4. A tabletted chewing gum sweet according to claim 1 wherein when the integral parts are arranged as layers, the individual layers are of the same or different thicknesses.
5. A tabletted chewing gum sweet according to claim 1 consisting of two layers wherein either layer is thicker than the other.
6. A tabletted chewing gum sweet according to claim 5 wherein the ratio of thicknesses is from 0.1:1 to 10:1.
7. A tabletted chewing gum sweet according to claim 5 wherein the first integral part of the tabletted chewing gum sweet according to the invention is thicker than the second integral part in a ratio of from 1.5:1 to 10:1.
8. A tabletted chewing gum sweet according to claim 1 wherein the tablet base material for both the first and second integral parts is based on a sugar or a polyol.

9. A tabletted chewing gum sweet according to claim 1 wherein the gum base is a plasticised rubber or polymer which has added texturisers, anti-tacking agents and antioxidants.

10. A tabletted chewing gum sweet according to claim 1 wherein the tablet base for both the first and second integral parts is sucrose, fructose, lactose, dextrose, sorbitol, mannitol, maltitol, xylitol, isomalt, glucose syrup, maltitol syrup or erithrithol.

11. A tabletted chewing gum sweet according to claim 1 wherein the particle sizes of the gum base and the tablet base materials of both the first and second integral parts range from 10 microns to 2mm.

12. A tabletted chewing gum sweet according to claim 1 wherein in the first integral part of the tabletted chewing gum sweet, the gum base is present in an amount of from 5% to 99%.

13. A tabletted chewing gum sweet according to claim 1 wherein the weight ratio of the first and second integral parts is from 1.5: 1 to 10:1.

14. A tabletted chewing gum sweet according to claim 1 containing a binder, a lubricant, a flavour or a colour.

15. A tabletted chewing gum sweet according to claim 1 wherein the first and second integral parts have different colours which provide contrasting effects to give a very distinctive and attractive visual indication of two components.

16. A tabletted chewing gum sweet according to claim 1 which gives a textural contrast when broken in the mouth of an initial crunchy and then a chewy sensation.

17. A tabletted chewing gum sweet according to claim 1 containing an active ingredient.

18. A tabletted chewing gum sweet according to claim 13 wherein the active ingredient is present in the second layer.

19. A tabletted chewing gum sweet according to claim 18 wherein the active ingredient is a pharmaceutical, medicated, nutritive or functional ingredient, a dental vehicle or a breath freshener.

20. A process for the preparation of a tabletted chewing gum sweet according to the invention in a configuration of two layers which comprises forming a first integral part by mixing a particulated gum base material with a particulated tablet base material, forming a second integral part comprising a particulated tablet base material, feeding one of the integral parts into a tablet press and compressing, feeding the other integral part into the tablet press and compressing both integral parts in the tablet press to enable the materials of each integral part to bind together and form a tabletted chewing gum sweet having the two integral parts joined together, and finally ejecting the tabletted chewing gum sweet.

21. A process according to claim 20 wherein the first integral part is fed into the tablet press before the second integral part to give the tabletted chewing gum sweet.

22. A process according to claim 20 wherein one or more further integral parts which are made of the same material as the first and second integral parts or of a different material to the first and second integral parts are fed into the tablet press and compressed to form a product with three or more layers.

23. A process for the preparation of a tabletted chewing gum sweet as claimed in claim 1 in a configuration of one integral part inlaid in another integral part which comprises feeding one of the integral parts into a tablet press and compressing into a shape having an indentation, feeding the other integral part into the indentation and compressing both integral parts in the tablet press to enable the materials of each integral part to bind together and form a tabletted chewing gum sweet having the two integral parts joined together, and finally ejecting the tabletted chewing gum sweet.

24. A process according to claim 23 wherein a further integral part is fed into the tablet press and compressed to cover and enclose the compressed integral part in the indentation.